

3/21/2018

[Dart Hawkesbury] Job Sheet - Gagnon-Donovan, Michelle



Dart Aerospace Ltd.
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D119-796-201
Job Sheet 174803



Part No: D119-796-201

Job Qty: 1 ea

Part Name: Aft Crosstube Installation With Step



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/21/18

Job Tracking No:

Due Date: 4/23/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV E IPP REV:A NEW ISSUE 14-09-05 DD VERF:JLM IPP REV:B 14.10.22 AS PER PA1 DD
VERF:JLM IPP REV:C 14.11.19 AS PER IIN REV:B DD VERF:JLM IPP REV D 15.02.13 AS PER REV C JLM
VERIFIED BY:DD IPP REV:E 15.05.13 PER REV D JLM VERIFIED BY:DD IPP REV:F 15.08.25 AS PER IIN
REV:E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/23/18	0.00	0.00	Start Up Stores/Pkg-1		APR 23 2018
110	Packaging	1 pcs		4/23/18	0.00	0.00	Packaging1-1		APR 25 2018
120	QC	1 pcs		4/23/18	0.00	0.00	QC4		SMB
125	DC	1 pcs		4/23/18	0.00	0.00	DC		
130	Packaging	1 pcs		4/23/18	0.00	0.00	Packaging3-1		SMB
140	QC21-FG	1 Ea		4/23/18	0.00	0.00	QC21		APR 25 2018

Part Op 125 - Photocopy bluefile & type labels per PPP D119-796-201 CHG004
Descriptions: 130 - Identify and pack for shipping as per PPP D119-796-201

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN5C32A	Bolt	4 Ea (4 ea)	90-Start up Operation	7131650
AN5C7A	Bolt	12 Ea (12 ea)	90-Start up Operation	5619411
D119-796-251	Aft Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	5023827
D3672-7	Washer, Phenolic	8 Ea (8 ea)	90-Start up Operation	3019307
DP460	Scotch Weld Adhesive	1 pcs (1 ea)	90-Start up Operation	5064031
MS21043-5	Nut	4 Ea (4 ea)	90-Start up Operation	7116548
MS21250-05048	Bolt (Use Ms21250-05-048)	4 Ea (4 ea)	90-Start up Operation	5039030
MS21920-28	Clamp	2 Ea (2 ea)	90-Start up Operation	5024479
NAS1149C0532R	Washer	8 Ea (8 ea)	90-Start up Operation	5055951
NAS1149C0563R	Washer	12 Ea (12 ea)	90-Start up Operation	714138409-2

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CART
AEROSPACE

Container No: S064055



Part: D119-796-201
Job No: 174803
Serial No/Batch: S064055
Revision:
Inspector:

Date: 04/23/18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN5C32A	4	78	0
	AN5C7A	12	140	0
	D119-796-251	1	0	0
	D3672-7	8	595	0
	DP460	1	5	0
	MS21043-5	4	151	0
	MS21250-05048	4	5	0
	MS21920-28	2	85	0
	NAS1149C0532R	8	189	0
	NAS1149C0563R	12	188	0
Part Specifications				
Specifications could not be found.				

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Change Record

PAGE 1 OF 1

Part Number: D119-796-201

Description: AFT CROSSTUBE INSTALLATION WITH PEG STEPS

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	OTHER : _____					
☐ Misidentified	☐ Past Due						

5.0 PARTS LIST

5.1 STANDARD GEAR CROSSTUBES

Item	-101	-201	-103	-203	-141	-241	-151	-251	Part Number	Description
	X								D119-796-101	FWD CROSSTUBE INSTALLATION WITH PEG STEPS
		X							D119-796-201	AFT CROSSTUBE INSTALLATION WITH PEG STEPS
			X						D119-796-103	FWD CROSSTUBE INSTALLATION W/O PEG STEPS
				X					D119-796-203	AFT CROSSTUBE INSTALLATION W/O PEG STEPS
			1		X		1		D119-796-141	CROSSTUBE INSTALLATION, STANDARD FWD, W/O PEG STEPS
				1		X		1	D119-796-241	CROSSTUBE INSTALLATION, STANDARD AFT, W/O PEG STEPS
	1						X		D119-796-151	CROSSTUBE INSTALLATION, STANDARD FWD, WITH PEG STEPS
		1						X	D119-796-251	CROSSTUBE INSTALLATION, STANDARD AFT, WITH PEG STEPS
1					4	4			D2873-043	RADIUS BLOCK
2	8	8	8	8					D3672-7	WASHER
3						1			D5122-1	CENTER SUPPORT
4						6			D5123-1	CLAMP CUSHION
5					4		4	4	D5123-3	CLAMP CUSHION
6						2			D5123-5	CLAMP CUSHION
7					2				D5124-1	FWD SUPPORT
8						1			D5134-041	DAMPER SUPPORT ASSY, LH
9						1			D5134-042	DAMPER SUPPORT ASSY, RH
10						1			D5136-1	CONTACT PAD, LH
11						1			D5136-2	CONTACT PAD, RH
12							2		D5149-041	FWD STEP ASSY
13								2	D5149-043	AFT STEP ASSY
14					2				D5152-041	FWD POST MOUNT ASSY
15						2			D5152-043	AFT POST MOUNT ASSY
16						2		2	D5515-1	GROUNDING CLAMP
17						2		2	AN174-3A	BOLT
18	12	12	12	12					AN5C7A	BOLT
19	4	4	4	4					AN5C32A	BOLT
20						16			CR3212-4-07	RIVET
21					16				CR3212-4-08	RIVET
22							4		MS21920-22	CLAMP
23					4				MS21920-24	CLAMP
24						6		4	MS21920-25	CLAMP
25		2		2		2			MS21920-28	CLAMP
26	4	4	4	4					MS21250-05048	BOLT
27						2		2	MS21042-3	NUT
28						2		2	MS21042-4	NUT
29	4	4	4	4					MS21043-5	NUT
30						2		2	MS27039-1-08	SCREW
31						4		4	NAS1149D0332J	WASHER
32						4		4	NAS1149D0432J	WASHER
33	8	8	8	8					NAS1149C0532R	WASHER
34	12	12	12	12					NAS1149C0563R	WASHER
100		1		1					DP460	SCOTCH WELD ADHESIVE (37mL)

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